

Shp 20/01/0

Work Order ID 111236

111236

Page 1

January-09-14 12:53:56 PM

Item ID: D4647-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 09/01/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

MAP/MLS

Date: 14-01-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4647

B

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-CUT AS PER DWG
DWG REV: B
PROG REV: B

2- Deburr

8 0 Jm14-01-15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

8 0 Jm14-01-15

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Item ID: D4647-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 09/01/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	DAS 27 9-89	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	14/1/15				8			
140 *140* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00			DAS 30 9-89		8			14/01/15
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 27 9-89 14/1/16				8			

Work Order ID 111236

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111236

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Item ID: D4647-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 09/01/2014 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Chemical Conversion Coat per QSI005 4.1	0.00				8		14-1-16	
-----	---	------	--	--	--	---	--	---------	--

160

HandFinish

Memo

0.00

Hand Finishing

170	QC7-Inspect Chemical Conversion Coat	0.00				8			
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170

QC

Memo

0.00

Quality Control

180	Identify as per dwg & Stock Location: 85116	0.00				8X		14-1-17	
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180

Packaging

Memo

0.00

Packaging

DAS
26
9-89

Work Order ID 111236***111236***

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Item ID: D4647-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 09/01/2014 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-20

14-01-17

Picklist Print

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Page 1

Work Order ID: 111236

111236

Parent Item: D4647-5

D4647-5

Parent Item Name: Doubler

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.06.20 NEW ISSUE DD VERF:JLM
13.07.17 AS PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

110

sf

251.9500

0.1098

①

M6061T6S 040

**

Jm14-01-15

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

251.95

m126350

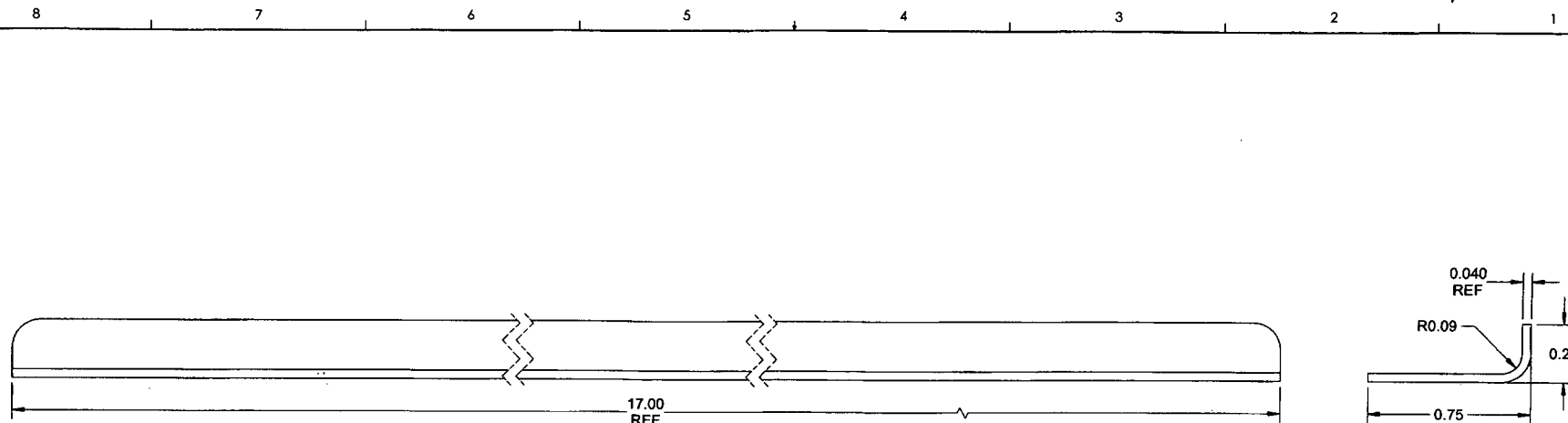
96

m126981

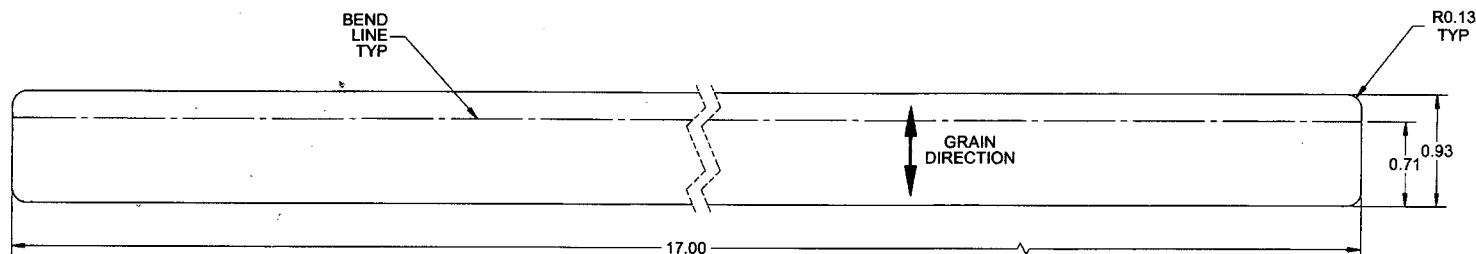
155.95

126350

111236
MCS
14-01-09



D4647-5 DOUBLER
MAKE FROM D4647-5F FLAT PATTERN



D4647-5F FLAT PATTERN DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

RELEASED
2013-07-15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4647	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	